

# Work Order ID 83512

**\*83512\***

Page 1

Thursday, April 19, 2012 10:25:56 AM

Item ID: D3363-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Console

Start Date: 4/19/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 4/27/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: *P*

Date: *12-04-19*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					<i>(4)</i>			
D3363	Rev C								

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3363 \*\*\*CUT AT 45 DEG GRAIN DIRECTION\*\*\*\*\*

*6661.063*

Dwg Rev: *E*

Prog Rev: *E*

2-Deburr if necessary

*B12-5-29*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*B12-5-29*

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*(4)*

*W 12:05 29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83512****\*83512\***

Page 2

Thursday, April 19, 2012 10:25:56 AM

Item ID: D3363-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Console

Start Date: 4/19/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 4/27/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Bend as per dwg NC BRAKE	0.00							SA 12/06/07
<b>*130*</b>						4			
Brake NC	Memo	0.00							
Brake NC	Debur Form as per Dwg D3363								
140	QC5- Inspect part completeness to step on W/O	0.00							WH 12-06-07
<b>*140*</b>						4			
QC	Memo	0.00							
Quality Control									
150	Weld per dwg A/R Aluminum rod Batch: 11120854	0.00							
<b>*150*</b>	Large Fab					4			12-06-01 ABZ
Large Fab	Memo	0.00							
Large Fab	1-Weld using DT8790 as per Dwg D3363 and QSI 004 2- Grind weld flush as per dwg								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*83512\***

Thursday, April 19, 2012 10:25:57 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**Start Date:** 4/19/2012      **Start Qty:** 4.00

**\*4\***

**Required Date:** 4/27/2012      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*160\***

QC

## Memo

0.00

### Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

**\*170\***

QC

## Memo

0.00

### Quality Control

1- inspect part with DT8790 jig

171

Chemical Conversion Coat per QSI005 4.1

0.00

**\*171\***

HandFinish

## Memo

0.00

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, April 19, 2012 10:26:02 AM

Page 1

Work Order ID: 83512

\*83512\*

Parent Item: D3363-1

\*D3363-1\*

Parent Item Name: Console

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B05.09.09Remove c'sink rivet holes and add welding stepKJ/JLM  
IPP: C 06.11.15 waterjet EC  
IPP Rev:D 08-07-14 add comment in QC5 inspection DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	286.8422	2.3	9.684211			

\*M6061T6S 063\*

6061-T6 .063 Sheet

\*\*

B12-5-2A

Location	Loc Qty	Loc Code
MAT021	286.8422000	
113608	0	
116308	6.01556842	
117285	67.544	
119331	44.2	
119802	20.94	
120218	21	
120866	127.142632	
121805		

4

121805

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	83512
<b>Description:</b> Console		<b>Part Number:</b>	D3363-1
<b>Inspection Dwg:</b> D3363	<b>Rev:</b> C	Page 1 of 2	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.099	2		V 1302	
Ø0.128	+0.005/-0.001	.132	2		V	
Ø0.469	+0.006/-0.001	.471	2		V	
14.41	+/-0.030	14.41	2		T 1301	
14.097	+/-0.010	14.097	2		T	
12.409	+/-0.010	12.409	2		T	
11.354	+/-0.010	11.360	2		PROW502	
10.706	+/-0.010	10.710	2		P	
10.081	+/-0.010	10.086	2		P	
4.331	+/-0.010	4.337	2		V	
3.706	+/-0.010	3.708	2		V	
3.058	+/-0.010	3.053	2		V	
2.004	+/-0.010	2.004	2		V	
2.366	+/-0.010	2.363	2		V	
3.100	+/-0.010	3.105	2		V	
5.040	+/-0.010	5.050	2		V	
5.415	+/-0.010	5.408	2		V	
2.25	+/-0.030	2.243	2		V	
19.965	+/-0.010	19.965	2		T	
20.366	+/-0.010	20.366	2		T	
21.318	+/-0.010	21.318	1		T	
22.90	+/-0.030	22.90	2		T	
0.315	+/-0.010				V	
3.706	+/-0.010	3.708	2		V	
4.025	+/-0.010	4.031	2		V	
7.206	+/-0.010	7.209	2		V	
1.75	+/-0.030	1.751	2		V	
10.387	+/-0.010	10.391	2		P	
19.590	+/-0.010	19.590	2		T	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	83512
<b>Description:</b> Console		<b>Part Number:</b>	D3363-1
<b>Inspection Dwg:</b> D3363	<b>Rev:</b> C	<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.990	+/-0.010	18.990	2		T 1B01	
1.80	+/-0.030	1.794	2		V 1B02	
6.390	+/-0.010	6.390	2		V	
5.790	+/-0.010	5.797	2		V	
4.475	+/-0.010	4.471	2		V	
4.100	+/-0.010	4.098	2		V	
2.725	+/-0.010	2.722	2		V	
2.00	+/-0.030	2.004	2		V	
6.363	+/-0.010	6.360	2		V	
10.737	+/-0.010	10.734	2		T 1	
11.206	+/-0.010	11.210	2		T	
3.206	+/-0.010	3.210	2		V	
3.675	+/-0.010	3.671	2		V	

<b>Measured by:</b> B	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12-5-09	<b>Date:</b> 12 05 29	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

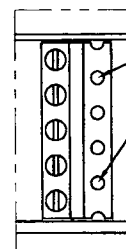


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
P11	P11			
CHECKED	APPROVED	DRAWING NO.		
5	off	D3363		
DATE		TITLE		
07.01.26		CONSOLE ASSEMBLY		
		NEW ISSUE		
		INCREASE WIDTH BY 0.125		
		T'DRILL DZUS RAIL, WIDEN BASE CUTOUT		
		REV. C		
		SHEET 1 OF 3		
		SCALE		
		1:5		

RELEASED

07.06.04

TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL  
THROUGH D3363-1 CONSOLE (TYP 4 PLACES)  
C'SINK (Ø0.225 X 100")  
FROM TOP SIDE OF CONSOLE



DETAIL C  
(SCALE 1:2)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *F3512*

INSTALL D3361-1 & D3362-1 USING  
MS20426AD4-6 RIVETS  
(TYP 9 PLACES)

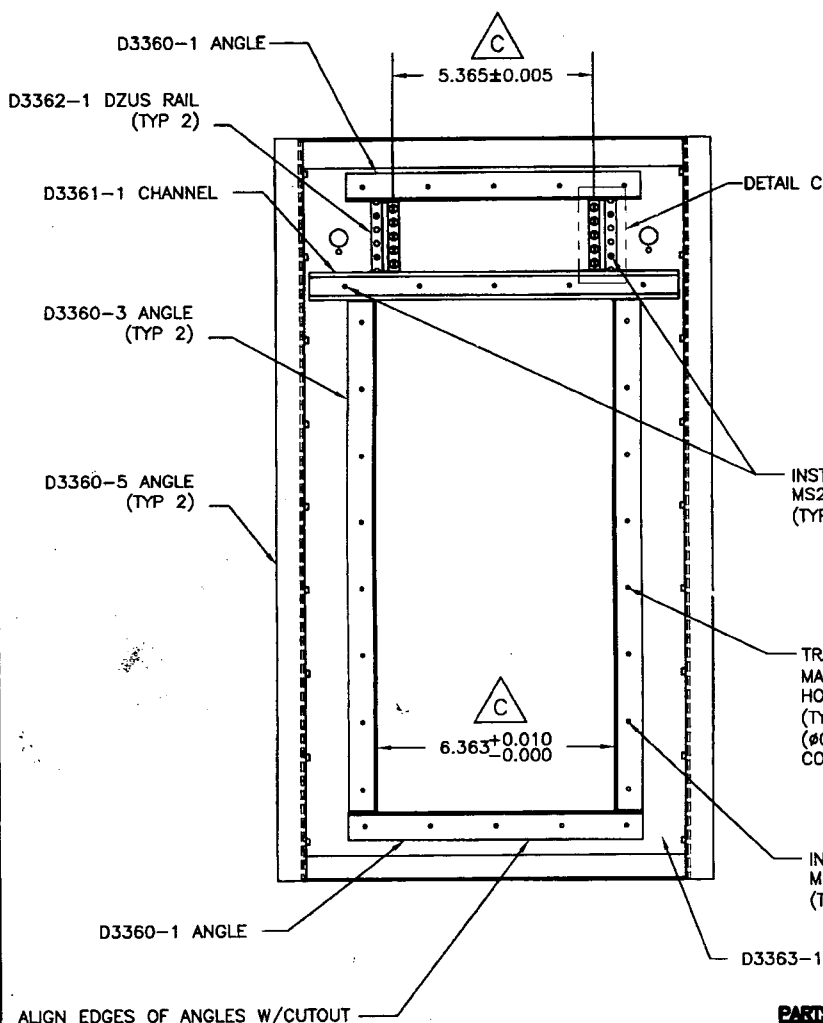
TRANSFER DRILL #30 FROM  
MATING PARTS THROUGH #40  
HOLES IN D3363-1 CONSOLE  
(TYP 49 PLACES) C'SINK  
(Ø0.225 X 100") FROM  
CONSOLE TOP SIDE

INSTALL D3360-1/-3/-5 ANGLES USING  
MS20426AD4-5 RIVETS  
(TYP 44 PLACES)

D3363-1 CONSOLE

**PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY**

QTY	PART NUMBER	DESCRIPTION
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET



**VIEW A-A FROM UNDER CONSOLE ASSEMBLY**

**D3363-041 CONSOLE ASSEMBLY**

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

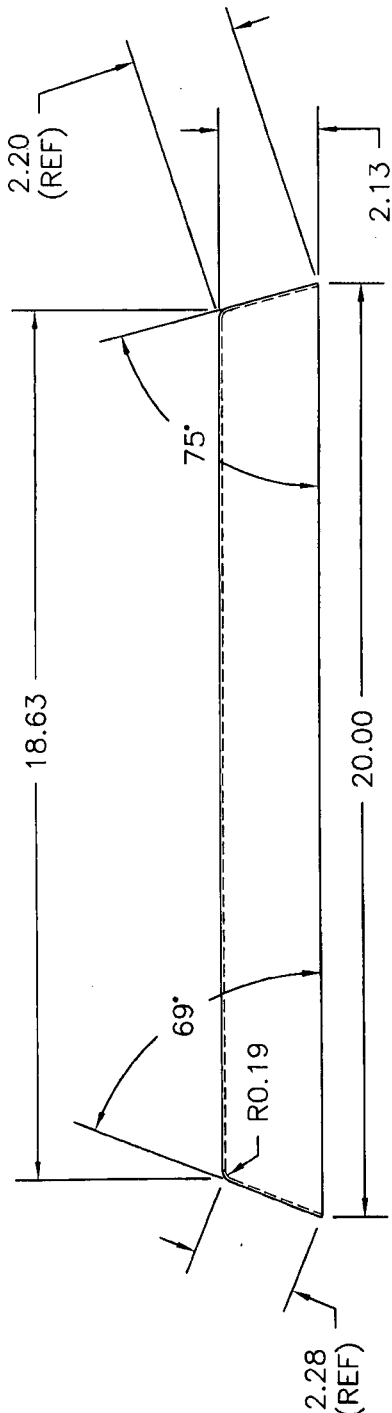




DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LS</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4

RELEASED

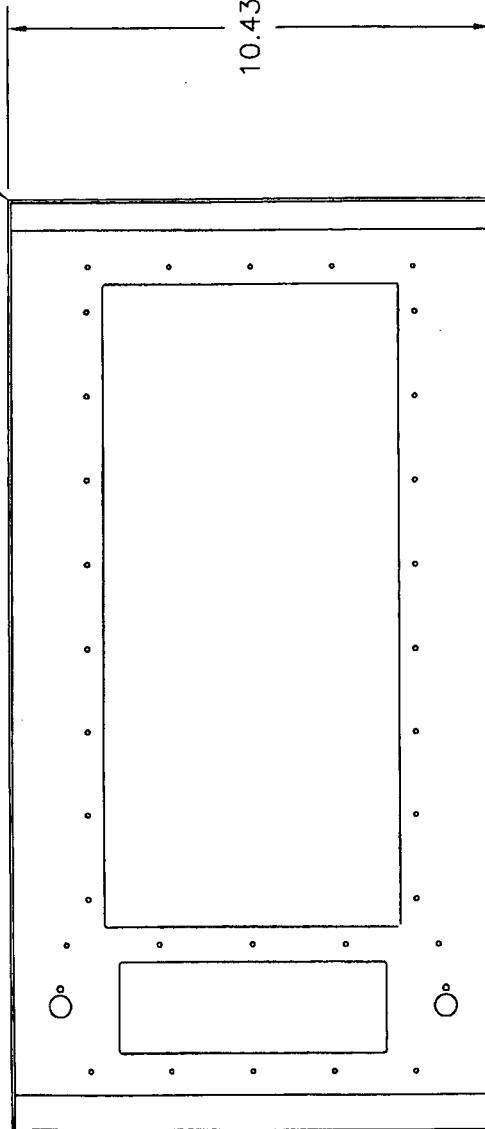
07.06.04 *[Signature]*



GRIND OUTSIDE  
WELD FLUSH  
(TYP 4 PLACES)

83512

10.430



**D3363-1 BEND DETAIL**  
(MAKE FROM D3363-1F FLAT PATTERN)

**D3363-1 CONSOLE**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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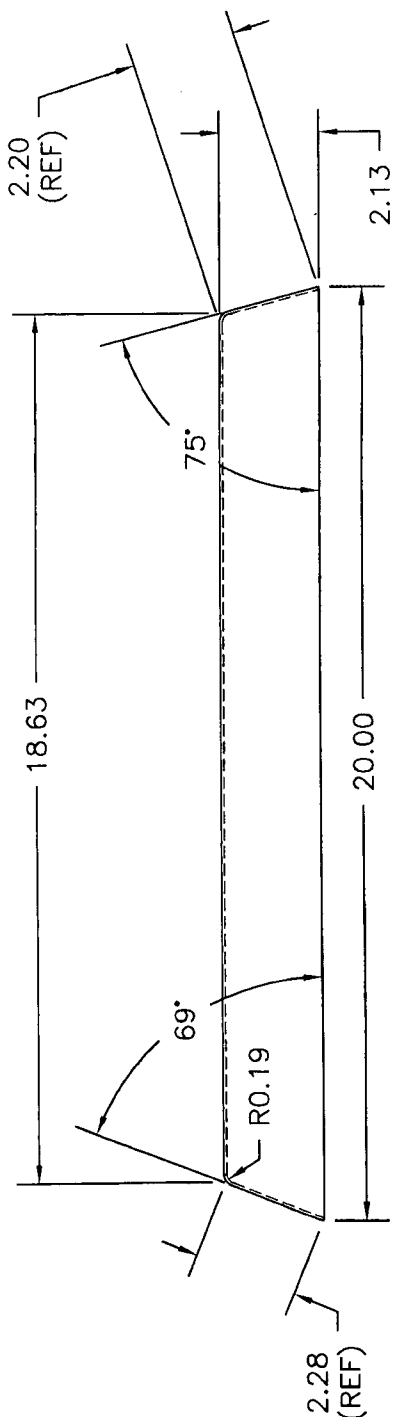


DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4

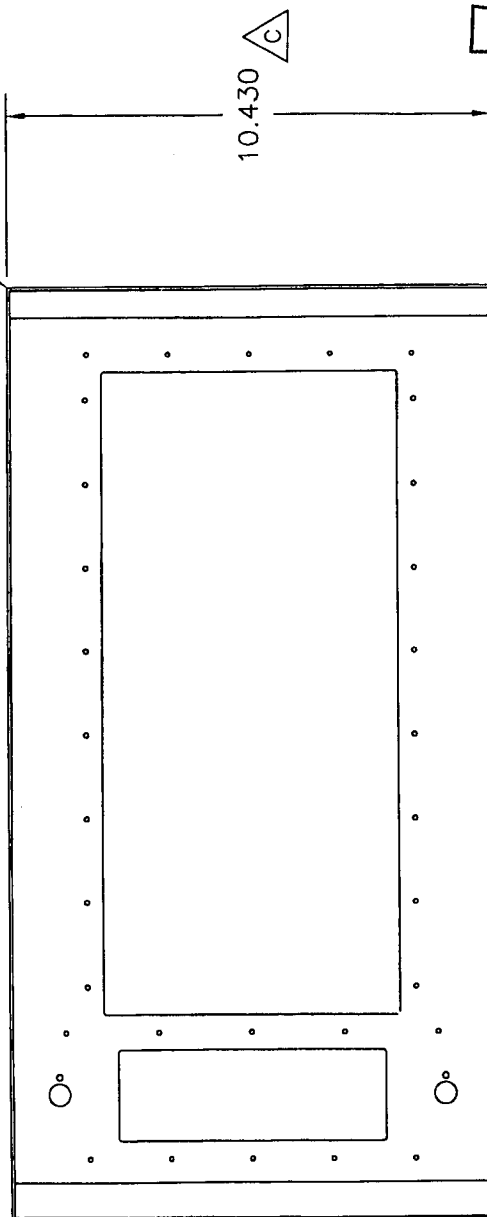
GRIND OUTSIDE  
WELD FLUSH  
(TYP 4 PLACES)

RELEASED

07.06.04 *[Signature]*



83512



**D3363-1 BEND DETAIL**

(MAKE FROM D3363-1F FLAT PATTERN)

**D3363-1 CONSOLE**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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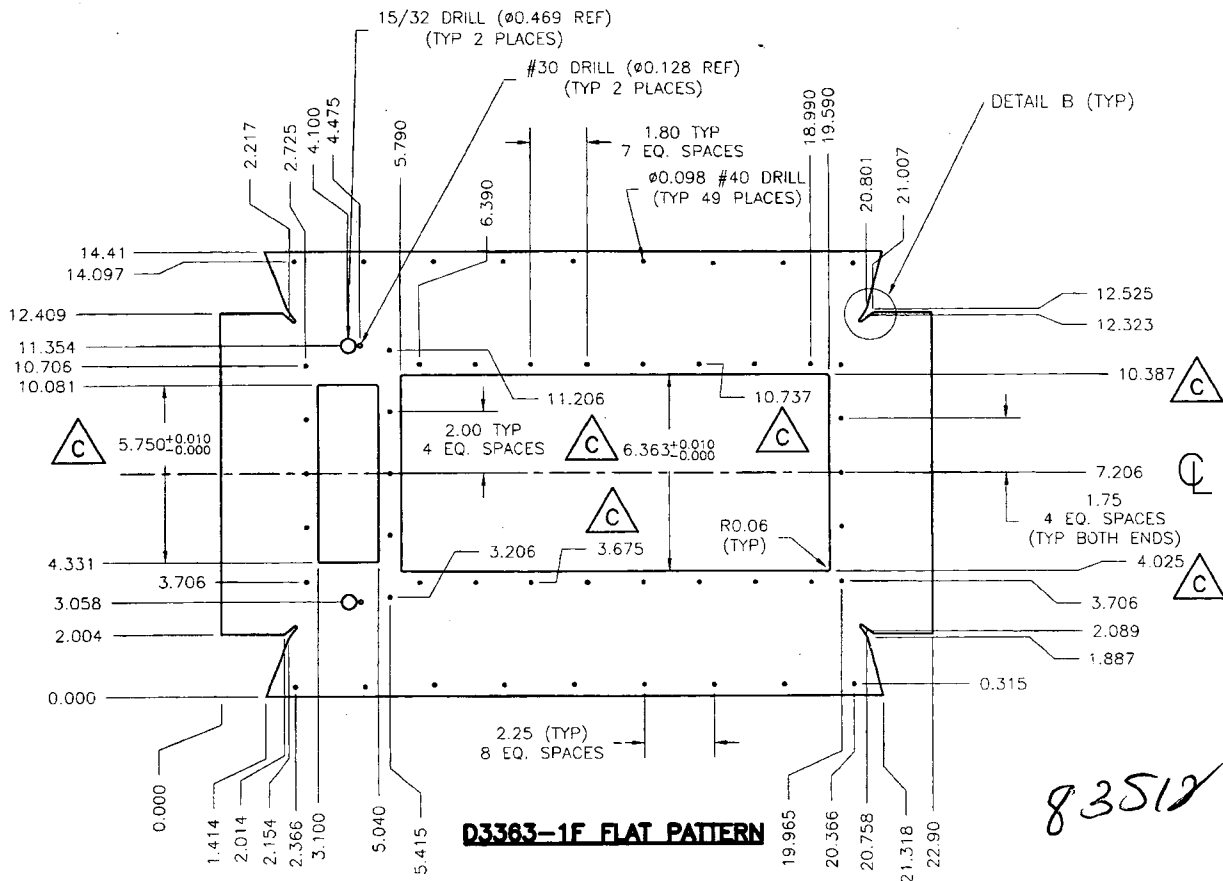
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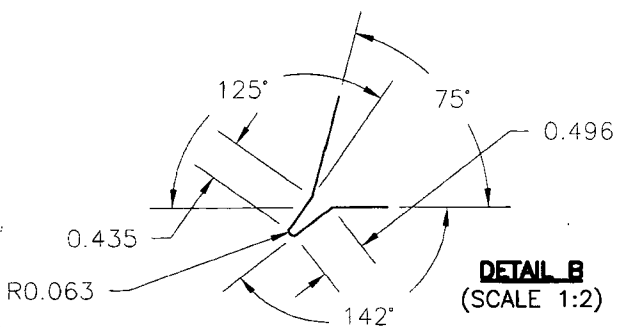


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
84	GH	DRAWING NO.	REV. C
CHECKED 3	APPROVED [Signature]	D3363	SHEET 3 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY	SCALE 1:6	

RELEASED  
07.06.04



D3363-1F FLAT PATTERN



**D3363-1F CONSOLE (FLAT PATTERN)**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

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W/O:		WORK ORDER CHANGES					
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